

Date: Friday, 15/08/2008 7:50:43 AM
User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D412-724-041
Job Number	: 41253		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D412724041
This Issue	: 15/08/2008 S.O. No. :	Drawing Number	: RESTOCK
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type. : SMALL /MED FAB	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	:	Due Date	: 22/08/2008 Qty: 2 Um: Each
Checked & Approved By	:		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT

16 08 18 2



2.0	D412724041	Head Rest Assembly, Center
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Head Rest Assembly, Center

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

W 8.8.21

RETURN TO STOCK USING
NEW B/N CHG001

FF 08-08-18

(2)

4.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

08/08/22

Job Completion



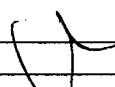
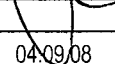
MF 08-08-21

*1.0 G.A:
Buff off powder coat up to
the shoulder of the D3304-1 tube.*



Date: Friday, 23/05/2008 11:33:30 AM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	REPLACEMENT HEADREST
Job Number :	39453		
Estimate Number :	10567		
P.O. Number :		Part Number :	D412724011
This Issue :	23/05/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	N/A
First Issue :	1/1	Project Number :	N/A
Previous Run :	38415	Drawing Revision :	N/A
	Type : SMALL /MED FAB	Material :	
Written By :		Due Date :	30/05/2008
Checked & Approved By :		Qty:	2 Um: Each
Comment :	Est Rev:A 04/09/08 New Issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-724-011 CHG001

JLD
08.5.23

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D412724041	Head Rest Assembly, Center
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Head Rest Assembly, Center

38956

50

4.0	D412724043	Head Rest Assembly, LH
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Head Rest Assembly, LH

38957

50

5.0	D412724044	Head Rest Assembly, RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Head Rest Assembly, RH

38958

8/5/23

(2x)

50

6.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

08-05-23 (2)

Date: Thursday, 14/08/2008 3:05:05 PM

User: Linda Lacelle

JOB HISTORY : DETAIL

Job Number	: 00196A	Customer	: Dart Aerospace Ltd.
Estimate Number	: 10068	DWG Name	: INITIAL PROTOTYPE TEMPLATE
Purchase Order #	:	Part Number	: INITIAL PROTOTYPE
Complete Date	: 31/07/2008 11:59:59	DWG-Number	: Rev.

4.0 D412724011-Replacement Head Rest INVENTORY ITEM					
DATE	EMPLOYEE	TYPE	Qty	COST	
02/06/2008	LAVO01: Lavoie, Chantal	D412724011	1.000	\$1067.14	Lot # 39453 Qty. 1
11/06/2008	LACE01: Lacelle, Linda	D412724011	-1.000	\$-1067.13	Lot # 39453 Qty. -1
Subtotal:			QTD: 0	CTD: 0	\$0.01

5.0 AN96010-Washer INVENTORY ITEM					
DATE	EMPLOYEE	TYPE	Qty	COST	
06/06/2008	LAVO01: Lavoie, Chantal	AN96010	18.000	\$0.36	Lot # 5519 Qty. 18
Subtotal:			QTD: 0	CTD: 18	\$0.36

6.0 AN960JD10-Washer INVENTORY ITEM					
DATE	EMPLOYEE	TYPE	Qty	COST	
06/06/2008	LAVO01: Lavoie, Chantal	AN960JD10	6.000	\$0.30	Lot # 108077 Qty. 6
Subtotal:			QTD: 0	CTD: 6	\$0.30

7.0 AN960JD10L-Washer INVENTORY ITEM					
DATE	EMPLOYEE	TYPE	Qty	COST	
06/06/2008	LAVO01: Lavoie, Chantal	AN960JD10L	40.000	\$1.04	Lot # 104885 Qty. 40
Subtotal:			QTD: 0	CTD: 40	\$1.04

8.0 AN525 10R22-Screw INVENTORY ITEM					
DATE	EMPLOYEE	TYPE	Qty	COST	
06/06/2008	LAVO01: Lavoie, Chantal	AN525 10R22	38.000	\$26.60	Lot # 107936 Qty. 38
Subtotal:			QTD: 0	CTD: 38	\$26.60

9.0 MS21042L3-Nut INVENTORY ITEM					
DATE	EMPLOYEE	TYPE	Qty	COST	
06/06/2008	LAVO01: Lavoie, Chantal	MS21042L3	38.000	\$5.53	Lot # 107644 Qty. 38
Subtotal:			QTD: 0	CTD: 38	\$5.53

10.0 D3763041-End Fitting Assembly INVENTORY ITEM					
DATE	EMPLOYEE	TYPE	Qty	COST	
11/06/2008	LACE01: Lacelle, Linda	D3763041	1.000	\$0.00	Lot # 39485 Qty. 1
Subtotal:			QTD: 0	CTD: 1	\$0.00

11.0 D37631-End Fitting INVENTORY ITEM					
DATE	EMPLOYEE	TYPE	Qty	COST	
11/06/2008	LACE01: Lacelle, Linda	D37631	1.000	\$0.00	Lot # 39483 Qty. 1
Subtotal:			QTD: 0	CTD: 1	\$0.00

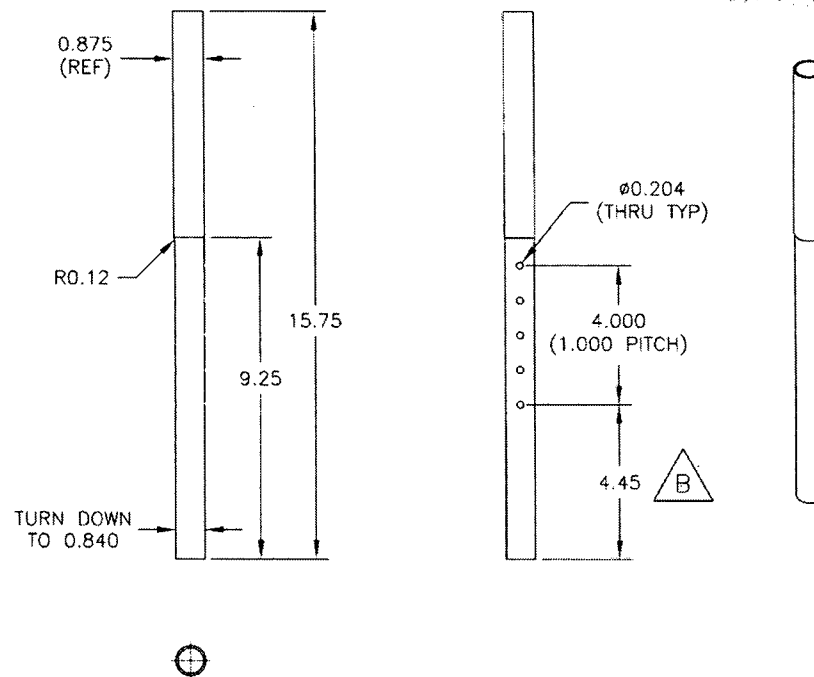
12.0 D37633-Tube INVENTORY ITEM					
DATE	EMPLOYEE	TYPE	Qty	COST	
11/06/2008	LECO01: Dawson, Julie	D37633	0.000	\$0.00	
11/06/2008	LECO01: Dawson, Julie	D37633	3.000	\$0.00	Lot # 39467 Qty. 3
Subtotal:			QTD: 0	CTD: 3	\$0.00

REFERENCE ONLY

REFERENCE ONLY



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3304	REV. B SHEET 2 OF 4
DATE 05.07.15	TITLE TUBE ASSEMBLY	SCALE 1:4	



RELEASED
05 08 16

14/12/15

D3304-1 TUBE

D3304-1 NOTES:

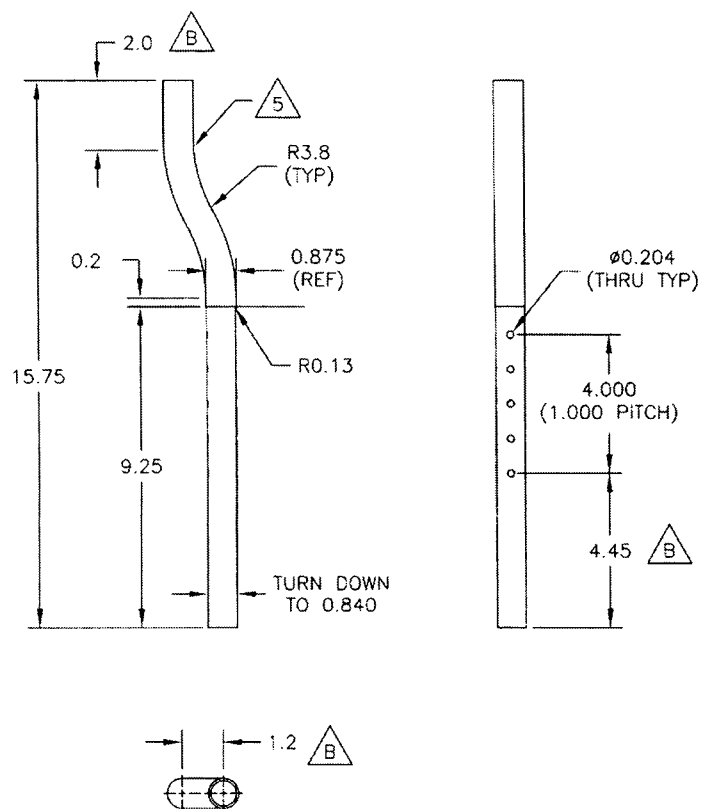
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE $\phi 0.875 \times 0.065$ WALL
(REF. DART SPEC M304TR0.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3304	REV. B SHEET 3 OF 4
DATE 05.07.15	TITLE TUBE ASSEMBLY		SCALE 1:4



D3304-3 TUBE

D3304-3 NOTES:

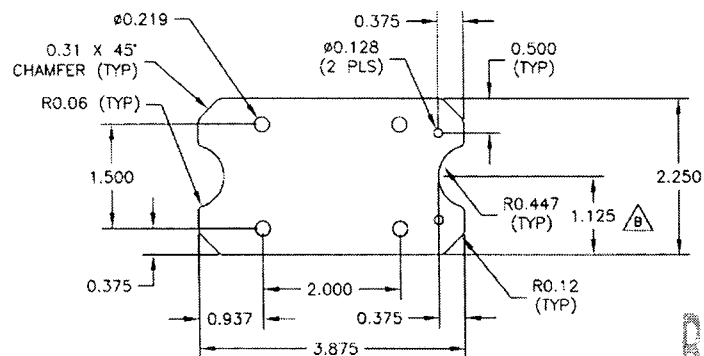
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE $\phi 0.875 \times 0.065$ WALL
(REF. DART SPEC M304TRO.875W.065) ENSURE SEAMLESS TUBE IS USED
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) BEND LINES 9.625, 13.375 DIMENSIONS

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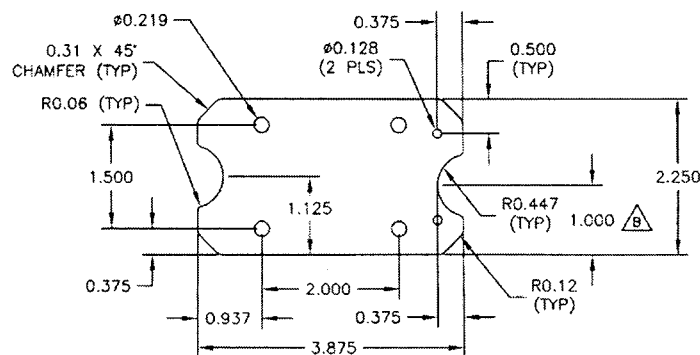
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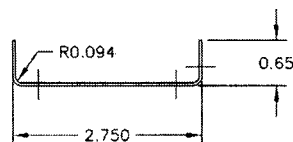
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3304	REV. B SHEET 4 OF 4
DATE 05.07.15	TITLE TUBE ASSEMBLY		SCALE 1:2



D3304-5 FLAT PATTERN



D3304-7/-8 FLAT PATTERN



**D3304-5/-7 BRACKET
D3304-8 OPPOSITE**

NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.040 THICK SHEET (REF. DART SPEC M304S20GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015

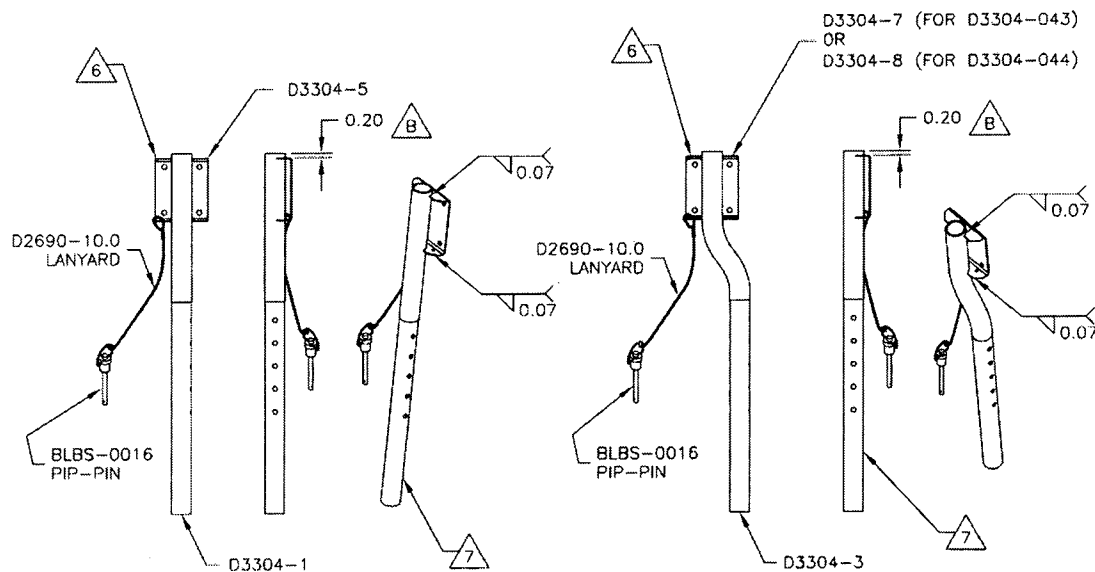
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RF	RF			HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED			DRAWING NO.	REV. B
				D3304	SHEET 1 OF 4
DATE				TITLE	SCALE
05.07.15				TUBE ASSEMBLY	1:6
A	04.08.18			NEW ISSUE	
B	05.07.15			UPDATE DIMENSIONS: ADD D3304-7/-8	



D3304-041 TUBE ASSEMBLY

**D3304-044 TUBE ASSEMBLY (SHOWN)
D3304-043 OPPOSITE**

D3304-041/-043/-044 NOTES:

- 1) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 2) WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) IDENTIFY AS INDICATED USING FINE POINT PERMANENT INK MARKER "TCCA-PDA, DART AEROSPACE LTD, P/N D3304-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"
- 7) IF BEING ASSEMBLED WITH D3303-041, ADD THE FOLLOWING USING A FINE POINT PERMANENT INK MARKER: "TCCA-PDA, DART AEROSPACE LTD, P/N D412-724-XXX B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

RELEASED
2015 08 11
Wb 4253